Work Order March-28-13 10:46		28		*989				Page 1			
Item ID: D3:	255-5			Accept	*N900	040	100) *	Setup St	art *	JS1*
Item Name: Gas	sket			12					St	top *\	IS 2*
Start Date: 4/0 Required Date: 4/0 Reference:		Start Qty: 10.0 Req'd Qty: 10.0	/• ·	n*	Cust Item Customer:					•	
Approvals: Pr	ocess Plan:	T. IM	Date: \2-154	{-⊙\ Tooling:	D	ate:	-]	Run St	art *	JR1*
	Process Plan: MLJ QC:		Date:		Date:				St	*NR1*	JR2*
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty		
Draw Nbr	Revisi	on Nbr									
D3255	Rev B		i -								
100	F	LOW WATER JET	•	0.00				_8	\sim		JM13-4-
Waterjet		Memo		0.00							
FLOW CNC Waterjet		1-Cut as Dwg Re	s per Dwg D3255 v:	e e							
		Prog Re	v: D								
		2-Debur	r if necessary								
110	C	C2- Inspect parts o	off machine FAI/FAIB	0.00							
110								0	_		7. 2 U

0.00

Memo

Quality Control

											DQA:	Date:		
NCR: Y	es /	No				WORK ORDER NON-C	100	VFORM	MANCE / UPI	DATE	OA Clasadi	Data		
- · · · · · · · · · · · · · · · · · · ·											QA Closed:	Date:		
Nork Orde	ŕ:					DISPOSITION			AGAINST DEPARTMENT/PROCESS					
Part N						Rework Scrap Use-as-is		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing			Proc Rec/Stor	Engineering Quality Other		
NCR N	o					Work Order Update			Large Fab	Composite		Supplier		
Root					Descri	ption of work order update		nitial	Act	ion	Sign &		·	
Cause	Da	ite	Step	Qty	(or Non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector	
oc/Data									-					
quip/Tooling		ļ												
perator		İ									1			
/laterial	_		:											
etup	_										i l			
ther														
rocess	_													
upplier	_	ļ												
raining	_	:												
Inapproved	i		-	l										
						•	AUL	T CATE	GORY					
Landir f	g Gear					General		ا ما		_	٦		la (5	
}	Bend	_			_,_	Bend		Grain		_	Ovalized		Pressure/Forced	
}			t Concer	ntric to	^{O/S} -	BOM/Route	-	Hardwa		-	Over/Under	<u> </u>	Temperature/Cure	
•	Crac				<u> </u>	Broken/Damaged	-	-	on Incomplete	<u> </u>	Part Incorrec		Weld	
-	_		Crimped		<u> </u>	Burrs	H		ions Incomplete/l	Inclear	Part Lost/Mis	ssing	Wrong Stock Pulled	
}	Cuff				<u> </u> -	Contamination	\vdash	Mainte		-	Part Moved	(n		
}	_	Trea		T L -	_	Countersink	\vdash	Mislabe		-	Positioned W		Other	
}	—		Strip in	ıube	-	Cut Too Short	\vdash	Misread	I	L	Power Loss/S	ourge	Jouner	
			Bend	.	_	Drill Holes	-	Offset	Salifanasi a -					
}	_		aves in E		n	Drawing	-	ł	Calibration					
	Turning Sequence Finish					\vdash	1	equence						
	Wave/Twist in Tube Folio				F0110		Outside	Dimensions						

Work Ord March-28-13 1		928	,	*980	128*						Page 2
Item ID: Revision ID: Item Name:	D3255-5 Gasket			Accept	*N900	040	100)* s	etup St	1.7	S1* S2*
Start Date: Required Date: Reference:	4/01/13 : 4/01/13	Start Qty: 10.00 Req'd Qty: 10.00	*10* *10*		Cust Item I Customer:	D:					· • • • • • • • • • • • • • • • • • • •
Approvals:		an:		-		ate:		R	tun St St	on	R1* R2*
Sequence ID/ Work Center II 120 *120* QC QC Quality Control	D	Operation Description QC8- Inspect parts - seco	nd check	Set Up/ Run Hours 0.00 0.00 0.00 13. 4. 6	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
*130 *130* Packaging Packaging		Identify as per dwg & Sto	ock Location:	0.00				8x) [-80 34-9.
*140 *140* QC Quality Control		QC21- Final Inspection - Memo	Work Order Release	0.00					13	14/10	40 NF 13-4-9

										DQA:	Date:		
NCR: Y	es / No				WORK ORDER NON-	CO	NFORI	MANCE / UPDA	TE				
F										QA Closed:	Date:	· · · · · · · · · · · · · · · · · · ·	
Work Orde	r·				DISPOSITION			AGAINST DEPARTMENT/PROCESS					
Part N	0				Rework Scrap Use-as-is Work Order Update	Scrap Machining Small Factorial Machining Small Machining Small Factorial Machining Small Factor			Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other	
Root				Descr	iption of work order update	Т	Initial	Action	1	Sign &			
Cause	Date	Step	Qty		or Non-conformance	CI	nief Eng	Descript	ion	Date	Verification	QC Inspector	
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved													
	- 6				General	AUI	LT CATE	GORY			·		
Landin	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped				Bend Grai BOM/Route Hard Broken/Damaged Inspendence Burrs Instr			ion Incomplete ions Incomplete/Unc	lear	Ovalized Over/Under Part Incorred Part Lost/Mi	t	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled	
1	Cuffs				Contamination	ı	Mainte	enance	i	Part Moved			

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Positioned Wrong

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Countersink

Cut Too Short

Drill Holes Drawing

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print

March-28-13 10:46:50 AM

Work Order ID:

98928

Parent Item:

D3255-5

Parent Item Name:

Gasket

Start Date: 4/01/13

Required Date: 4/01/13

Page 1

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP A04.05.12New issueKJ/RF

IPP Rev:B Now On Waterjet 06-08-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item _	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3255 Gasket		Manufactured	No ·			110	sf	11.5000	1.5411	16 .222 105			Jm,3-4-
•				Location		Loc Qty	Ţ	oc Code					
		•		MAT052	7	11.5 11.5			87	SUZ			

											DC	(A:	Date	:
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UP	PDATE				
									-		QA Close	ed:	Date	:
Work Ord	er:					DISPOSITION		AGAINST DEPARTMENT/PROCESS						
						Rework]		Skid-tube Crosstube] .	Water Jet Prod. Eng. Coor.		Engineering
Part	NO.					Scrap Machining Small Fab Use-as-is Thermoforming Finishing			Finishing	-		_	Quality Other	
NCR	No.		•			Work Order Update Large Fab Composite			Rec/Store/Packaging Supplier			other _		
Root					Descri	ption of work order update		Initial	Ac	ction	Sign &			
Cause		Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Desc	cription	Date	Ve	erification	QC Inspector
Doc/Data						,								
Equip/Tooling													•	:
Operator														
Material											İ			
Setup														*
Other											1			
Process														
Supplier														
Training	L]											
Unapproved	L										<u> </u>			<u> </u>
		_					AUI	LT CATE	GORY					
Landi	ng (1			_	General	_	,		_	7			- 7
	_	Bending				Bend		Grain			Ovalized		<u> </u>	Pressure/Forced
		Centre N	ot Conce	ntric to	o/s	BOM/Route	L	Hardwa		_	Over/Und	ler toler	ance	Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Inco	rrect		Weld
		Crushed/	Crimped			Burrs		-1	ions Incomplete	/Unclear	Part Lost,	_	L	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance ⁻	<u></u>	Part Mov			
	Ŀ	Heat Trea	at			Countersink		Mislabe	led	<u></u>	Positione	d Wron	g	
ļ		Inspectio	n Strip in	Tube		Cut Too Short	Misread			Power Lo	ss/Surge	•	Other	

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE LTD	Work Order:	98928
Description: Gasket	Part Number:	D3255-5
Inspection Dwg: D3255 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article	Prototype
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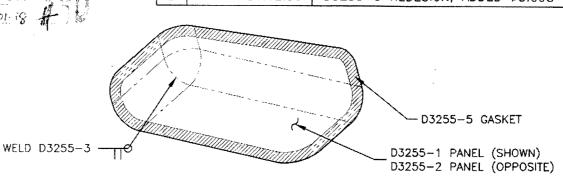
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.00	+/-0.030	1.00"	V		U	Times
18.46	+/-0.030	18.46	~		T	Ikmou
11.43	+/-0.030	11.43"			·γ	Parwier
15.36	+/-0.030	15.36"	~		T	
6.90	+/-0.030	6.987	~ ·		V	
0.063	+/-0.010	0.060"			√	
			i			
						·

Measured by: Jm	Audited by:	Prototype Approval: N/A
Date: 13-4-8	Date: 13 4, 9	Date: N/A

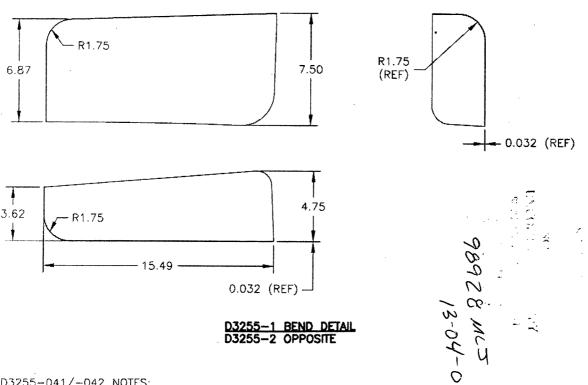
Rev	Date	Change	<u> </u>	Revised by	Approved
Α	07.07.18	New Issue		KJ/JLM	R
				70	



DESIG	N TA	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA							
CHEC	KED , O	APPROVED	DRAWING NO. REV	. В						
	\mathcal{A}'	- H	D3255 SHEET 1 OF	F 4						
DATE			TITLE SC	ALE						
 04.1	2.06		ACCESS PANEL ASSEMBLY	1:6						
Α		04.01.27	NEW ISSUE							
В		04.12.06	D3255-3 REDESIGN; ADDED Ø0.098							



D3255-041 ACCESS PANEL (SHOWN) D3255-042 ACCESS PANEL (OPPOSITE)



- D3255-041/-042 NOTES:

 1) WELD PER DART QSI 004

 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3

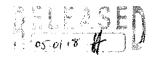
 3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS
- 4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

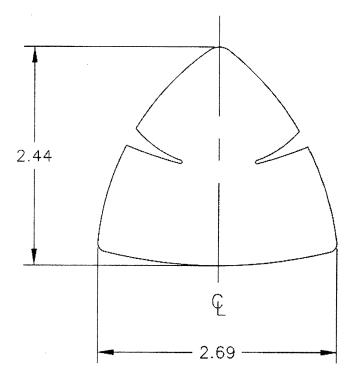
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DESIGN	DRAWN BY	1	ROSPACE LTD y, ontario, canada
CHECKED	APPROVED	DRAWING NO.	REV. B
47	1	D3255	SHEET 2 OF 4
DATE		TITLE	SCALE
04.12.06		TITLE	1:1





D3255-3 CAP FORM TO FIT D3155-1/-2

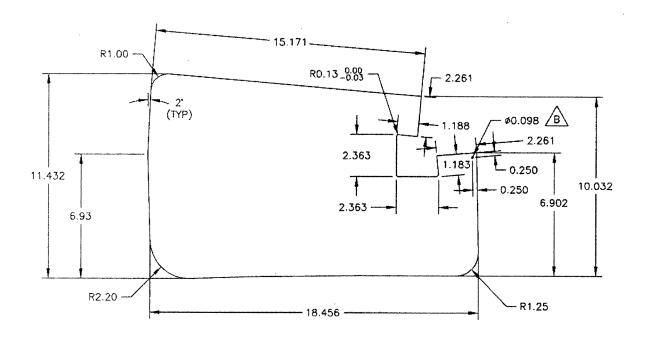
D3255-3 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MAKE PER DRAWING "D3255-B2.DWG"



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
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DATE		TITLE	WINAMEN	SCA	LE
04.12.06		ACCESS PANEL ASSEMBLY		1	1:5





D3255-1/-2 FLAT PATTERN

D3255-1/-2 NOTES:

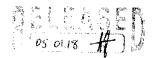
- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLÈSS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

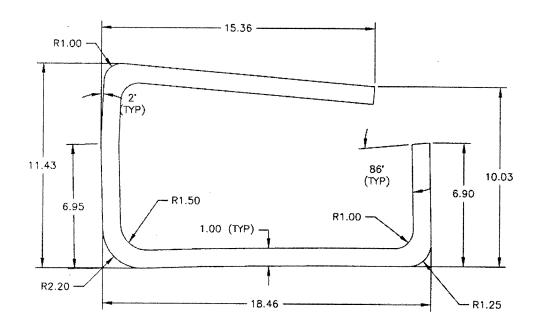
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CHECKED	APPROVED	DRAWING NO.	REV. B
4		D3255	SHEET 4 OF 4
DATE		TITLE	SCALE
04.12.06		ACCESS PANEL ASSEMBLY	1:5





D3255-5 GASKET

<u>D3255-5 NOTES</u>:

- 1) MATERIAL: SILICONE COATED FIBERGLASS CLOTH PER AMS 3320F P/N SIL/F 36x36x1/16 POSSIBLE SUPPLER: AVIALL
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 3) ALL DIMENSIONS ARE IN INCHES